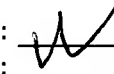
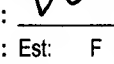


Date: Thursday, 10/08/2006 10:01:09 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARPLATE
Job Number : 28122	
Estimate Number : 10299	
P.O. Number : N/A	Part Number : D25775
This Issue : 10/08/2006 S.O. No. : N/A	Drawing Number : D2577 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : PURCHASED PARTS	Drawing Revision : E
Previous Run : 27557	Material : N/A
Written By : 	Due Date : 30/08/2006
Checked & Approved By : 	Qty: 23 Um: Each
Comment : Est: F 02.09.24 Re-format KJ/RF Est Rev:D Now on Waterjet 06-06-14 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M1010S16GA	1010/1025/A21/6aA SHEET
-----	------------	-------------------------



Comment: Qty.: 1.0301 sf(s)/Unit Total : 20.6010 sf(s)
1010/1025 16GA SHEET
(m1010s16ga)
Batch: M101463

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
1-Cut as per Dwg D2577
Dwg Rev: E
Prog Rev: E

2-Deburr if necessary

SAD 06:08:14 23
SAD 06:10:17 23

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--




Comment: DIMENSIONAL CHECK
Inspect dimensions per template D2577-5T1

SAD 06:08:14 23

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

 06-09-25

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: PA Date: 06/12/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 10/08/2006 10:01:09 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 28122

Part Number: D25775

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr

N/A

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE
1-Form on brake using DT8155 and DT8179 as per Dwg D2577
2-Form joggle using DT8157 as per Dwg D2577
3-Identify as D2577-5

SB 06/11/14 (23)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06/11/14 (23)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING
Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

9.M 06/12/04 (23X)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FC 06/12/05 (23)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: F19

FC 06/12/05 (23)

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

06/12/05 (23)

Job Completion



N 06/12/05

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

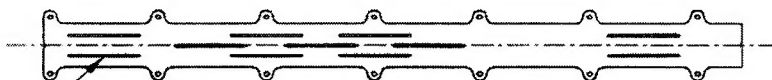
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART**RELEASED**
00 09 22

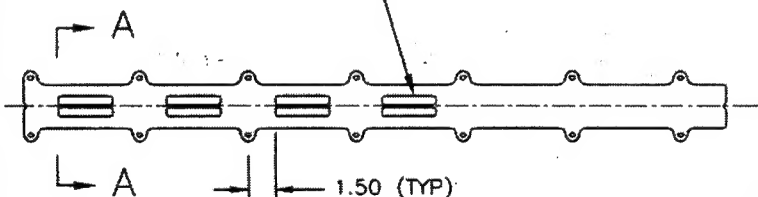
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CHECKED	APPROVED	DRAWING NO.	REV. E	
		D2577	SHEET 1 OF 5	
DATE		TITLE	SCALE	
00.09.22		WEARSHOE	1:10	
A	96.09.16	NEW ISSUE		
B	96.12.04	ADD HARDCOAT WELDS		
C	97.05.30	CHANGE HOLES TO OBROUNDS		
D	98.08.17	CORRECTED DIMENSIONS ON -1 & -3		
E	00.09.22	ADD D2577-101/-11/-13 INCORPORATE DE09176		

7560 HARDCOAT WELD
4.0 LONG
0.063 TO 0.125 HIGH
(TYP. 11 PLS.)
WELD AFTER BENDING AS
ILLUSTRATED PER DT8308

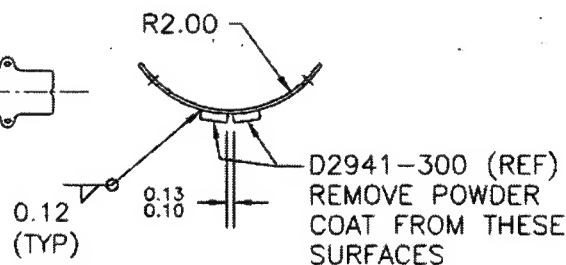


D2577-1 & D2577-3 WEARSHOE
MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY
FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D2941-300
SHWAYDER WEAPADS
(8 PLACES)



SECTION A-A
SCALE 1:5

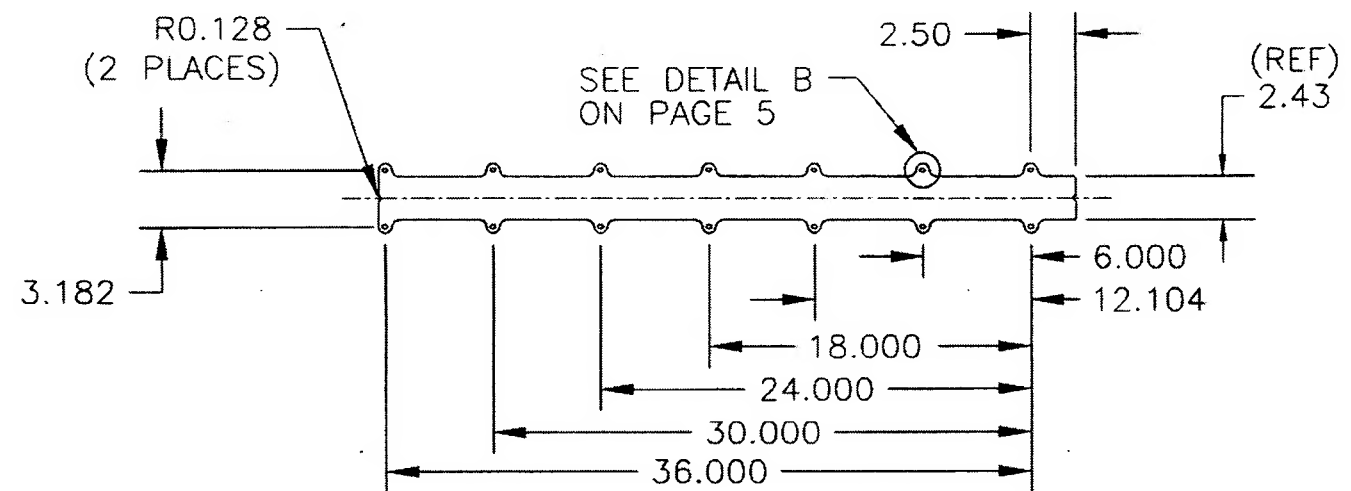


D2577-21 & D2577-23 WEARSHOE
MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY
FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

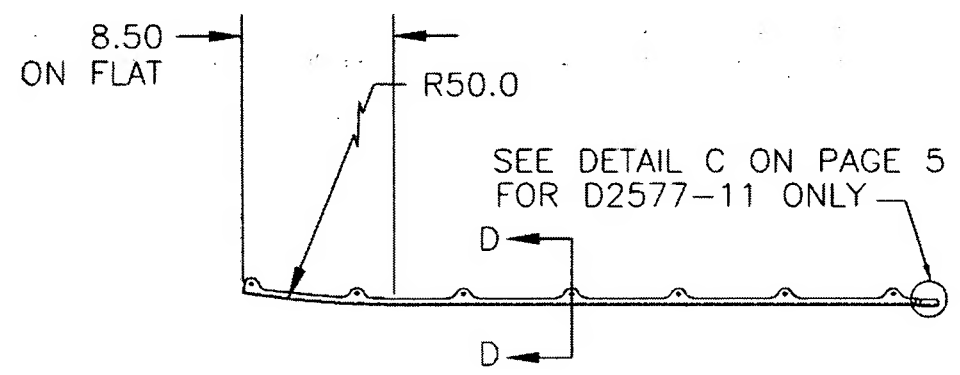
DART



DESIGN	✓	DRAWN BY	GP	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA
CHECKED	✓	APPROVED	✓	DRAWING NO. D2577
DATE	00.09.22	TITLE	WEARSHOE	SHEET 2 OF 5
		SCALE	1:10	REV. E



D2577-101 FLAT PATTERN
 BREAK ALL SHARP CORNERS 0.010 TO 0.020
 MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570
 SERIES STEEL 0.063 THICK
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2577-11 & D2577-13 LONGITUDINAL BEND
 MAKE FROM D2577-101
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
 00 09 22

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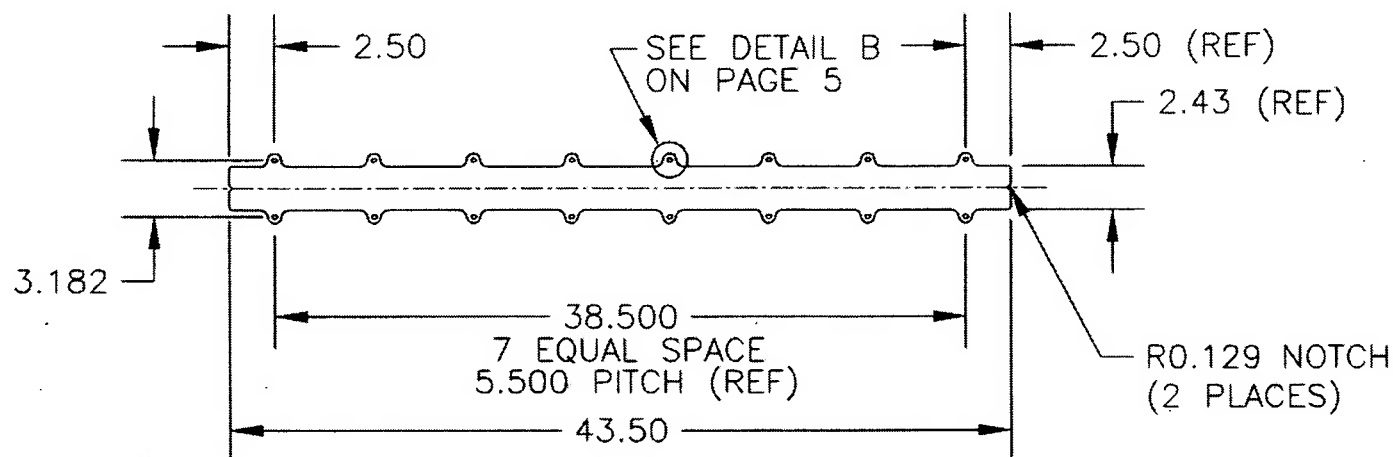
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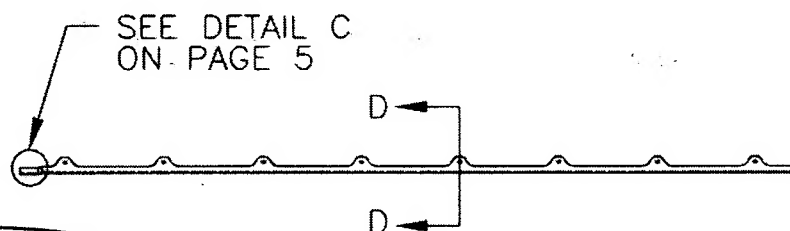
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CHECKED	APPROVED	HAMKESBURY, ONTARIO, CANADA
DATE	DRAWING NO.	REV. E
00.09.22	D2577	SHEET 3 OF 5
	TITLE	SCALE
	WEARSHOE	1:10

RELEASED
00.04.26

D2577-5 FLAT PATTERN



D2577-5 LONGITUDINAL BEND



D2577-5 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570

SERIES STEEL 0.063 THICK

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

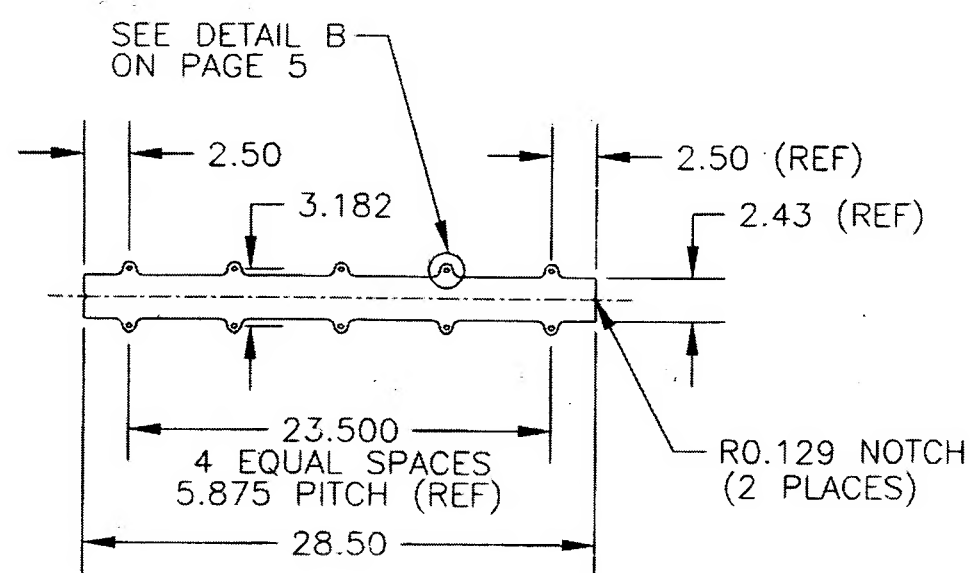
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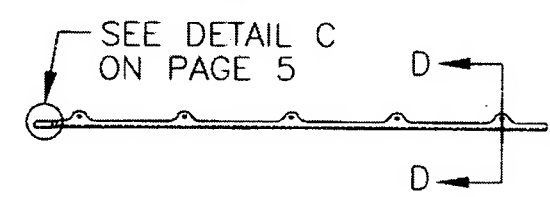
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CHECKED	APPROVED	DRAWING NO. D2577	SHEET 4 OF 5
DATE 00.09.22		TITLE WEARSHOE	SCALE 1:10

RELEASED
00 09 26

D2577-7 FLAT PATTERN



D2577-7 LONGITUDINAL BEND



D2577-7 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020
 MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570
 SERIES STEEL 0.063 THICK
 FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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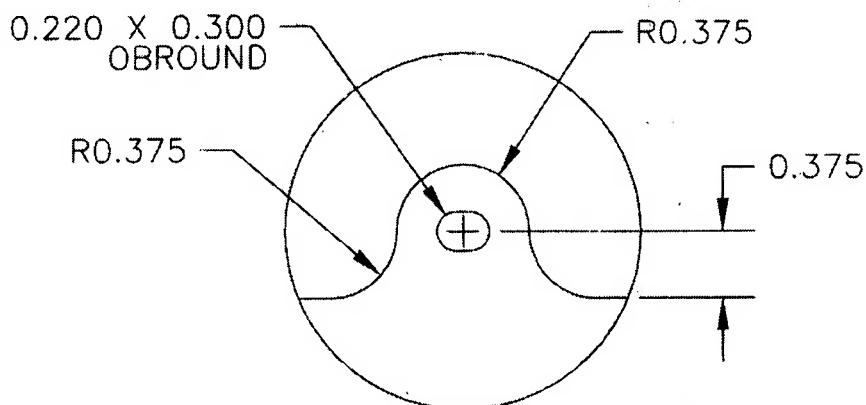
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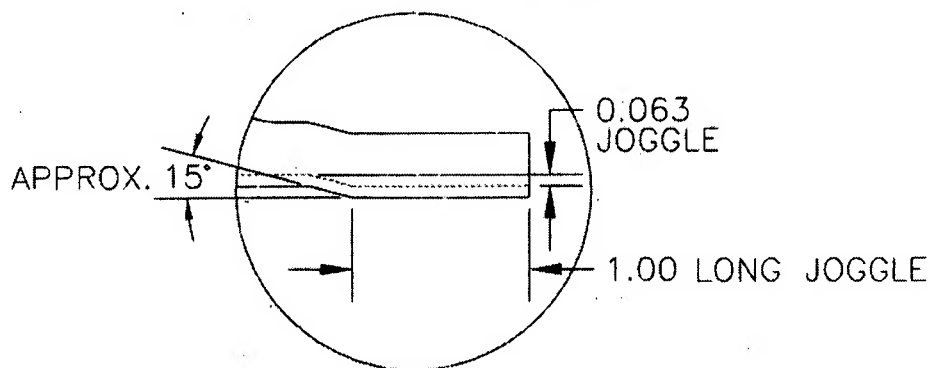
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CHECKED #	APPROVED #	DRAWING NO. D2577	REV. E SHEET 5 OF 5
DATE 00.09.22		TITLE WEARSHOE	SCALE 1:10

RELEASED
00.09.26

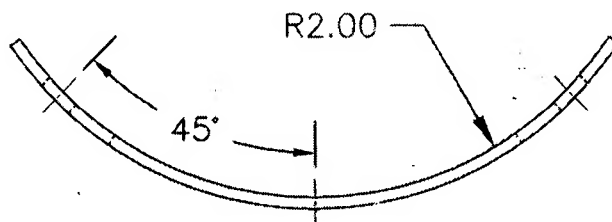
DETAIL B (SCALE 1:1)



DETAIL C (SCALE 1:1)



SECTION D-D (SCALE 1:1)



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DART AEROSPACE LTD		Work Order: 28122
Description: <u>WEARSHOE</u>		Part Number: D2577-5
Inspection Dwg:	Rev: <u>E</u>	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.50	± 0.030	2.503	✓		Vern	
3.182	± 0.010	3.182	✓		Vern	
43.50	± 0.030	43.50	✓		Vern measuring tape	
38.500	± 0.010	38.50	✓		Vern measuring tape	
2.50	± 0.030	2.50	✓		Vern	
2.43	± 0.030	2.439	✓		Vern	
R0.129	± 0.010	R0.129	✓		R-G	
0.220	± 0.010	0.217	✓		Vern	
0.300	± 0.010	0.302	✓		Vern	
0.375	± 0.010	0.370	✓		Vern Vern	
0.063	± 0.010	0.062	✓		Vern	

Measured by: <u>SAD</u>	Audited by: <u>[Signature]</u>	Prototype Approval: <u>N/A</u>
Date: <u>06-08-14</u>	Date: <u>06-09-25</u>	Date: <u> </u>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	